

54270 DeRev.

## Work Order ID 53914



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November 23, 2009 2:45:08 PM

Item ID:	D2841-041	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Step Assembly, 206 Float					
Start Date:	23/11/2009	Start Qty:	4.00	Cust Item ID:		
Required Date:	23/11/2009	Req'd Qty:	4.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	09/11/23	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2841	Rev B								
100	Large Fab	0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut D2841-1 using D2622 extrusion as per Dwg D2841 □2-Drill extrusion per drawing D2841 using Jig DT 8265 □3-Deburr and bevel ends for welding								
110	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
120	Large Fab	0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Weld end cap(AFT END ONLY) □2-weld lugs as per Dwg D2841 □using Jig DT 8267 followed by DT 8268 □A/R AL ROD Batch: m111311 □3-Grind end cap welds flush								

09.11.24

Salul25

09.11.26

m111494

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 53914**

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Item ID: D2841-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step Assembly, 206 Float

Start Date: 23/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 23/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 09.11.26

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

7/809/11/26

(X/24) 7

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

7/809.11.26

4 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 53914

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Item ID: D2841-041  
 Revision ID: B  
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 Start Date: 23/11/2009 Start Qty: 4.00  
 Required Date: 23/11/2009 Req'd Qty: 4.00  
 Reference:

Accept



Setup Start



Stop



Cust Item ID:  
 Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							
170 	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	1-Inspect for foreign object per QSI 024 D2841 □A/R AL ROD Batch: <u>1111311</u> welds flush as per dwg D2841 4- Touch up with Aboline umd 09/11/30								
180 	QC10- Inspect visual per QSI004- ground welds	0.00							
QC Quality Control	Memo	0.00							

*10/11/27*

*4*

*10/11/27*

*27 10/11/30*

*4*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item Name:	Step Assembly, 206 Float					
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Required Date:	23/11/2009	Req'd Qty:	4.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		2) 5 or 11/30		(444) /			
200  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3 Alum Memo START TIME: 10:45 3:20 FINISH TIME: 11:13 OVEN TEMPERATURE:	0.00  0.00			BF 09-12-01	(444)			
210  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00			MD 09/12/01	44			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Work Order ID 53914

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Start Date:	23/11/2009	Start Qty:	4.00	Cust Item ID:		
Required Date:	23/11/2009	Req'd Qty:	4.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	HandFinishing	0.00							
	HandFinish								
Hand Finishing	Memo	0.00							
	1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: <u>m 112623 (wingwalk/K)</u>								
	SiKaflex: m112345 exp: 10/08								
230	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
Quality Control	Memo	0.00							
	2) Sorln102								
240	Identify as per dwg & Stock Location:	0.00							
	Packaging								
Packaging	Memo	0.00							
	PDP 52/59								

WWD 09/12/02

XYLH

09/12/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 53914**

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Item ID: D2841-041  
Revision ID: B  
Item Name: Step Assembly, 206 Float

Accept



Setup Start



Stop



Start Date: 23/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 23/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/07

MF  
09-12-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 53914

Parent Item: D2841-041RevB

Parent Item Name: Step Assembly, 206 Float

Comments:

Start Date: 23/11/2009

Required Date: 23/11/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960C10L		Purchased	No			100	Each	2,604.000	16.0000			
-----------	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--



washer

Warehouse	Location	Loc Qty	Loc Code
OFFSHORE			
	FG	100	
	103585	100	
Main Warehouse			
	ST	2504	
	112116	548	
	112612	956	
	(112933)	1000	

D2622-120CRevC1

Manufactured No

120	Each	95.3200	4.0000
-----	------	---------	--------



Step Extrusion

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse			
	WA	95.32	
	48612	11.62	
	52026	83.7	

X16 MD 09/11/02  
 13 09.11.24

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

Page 2

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Work Order ID: 53914

Parent Item: D2841-041RevB

Parent Item Name: Step Assembly, 206 Float

Comments:

Start Date: 23/11/2009

Required Date: 23/11/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2734RevC

Manufactured

No

120

Each

39.0000

8.0000



Step End Plate

*Ph 09.11.26*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

39

43535

2

48110

37

D3464-1RevA

Manufactured

No

120

Each

32.0000

4.0000



Float Step Mounting Plate

*Ph 09.11.26*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

32

37348

8

44607

24

D3464-3RevA

Manufactured

No

120

Each

27.0000

4.0000



Float Step Mounting Plate

*Ph 09.11.26*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

27

37349

12

37791

15

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 53914

Parent Item: D2841-041RevB

Parent Item Name: Step Assembly, 206 Float







Comments:

Start Date: 23/11/2009

Required Date: 23/11/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3464-5RevA  Float Step Mounting Plate		Manufactured	No			120	Each	6.0000	4.0000 		<u>Ph 09.11.26</u>	
<div><div>Warehouse</div><div>Location</div><div>Main Warehouse</div><div>ST</div><div>25427</div><div>Loc Qty</div><div>6</div><div>6</div><div>Loc Code</div></div>												
D3464-7RevA  Float Step Mounting Plate		Manufactured	No			220	Each	25.0000	4.0000 		<u>Ph 09.11.26</u>	
<div><div>Warehouse</div><div>Location</div><div>Main Warehouse</div><div>ST</div><div>25428</div><div>44608</div><div>Loc Qty</div><div>25</div><div>6</div><div>19</div><div>Loc Code</div></div>												
MS27039C1-07  screw		Purchased	No			220	Each	46.0000	16.0000 			
<div><div>Warehouse</div><div>Location</div><div>Main Warehouse</div><div>ST</div><div>107008</div><div>111424</div><div>Loc Qty</div><div>46</div><div>1</div><div>45</div><div>Loc Code</div></div>												

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

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November 23, 2009 2:45:34 PM

Work Order ID: 53914

Parent Item: D2841-041RevB

Parent Item Name: Step Assembly, 206 Float



Start Date: 23/11/2009

Required Date: 23/11/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1329C3KB130  insert		Purchased	No			220	Each	98.0000	16.0000			
				<u>Warehouse</u>	<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>			
				Main Warehouse								
				ST				98				
					111981			98				
NAS1515H3L  WASHER		Purchased	No			220	Each	266.0000	16.0000			
				<u>Warehouse</u>	<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>			
				OFFSHORE								
				FG				40				
					102472			40				
				Main Warehouse								
				ST				226				
					110450			2				
					111819			224				

X16 MD 09/12/02

X16 MD 09/12/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

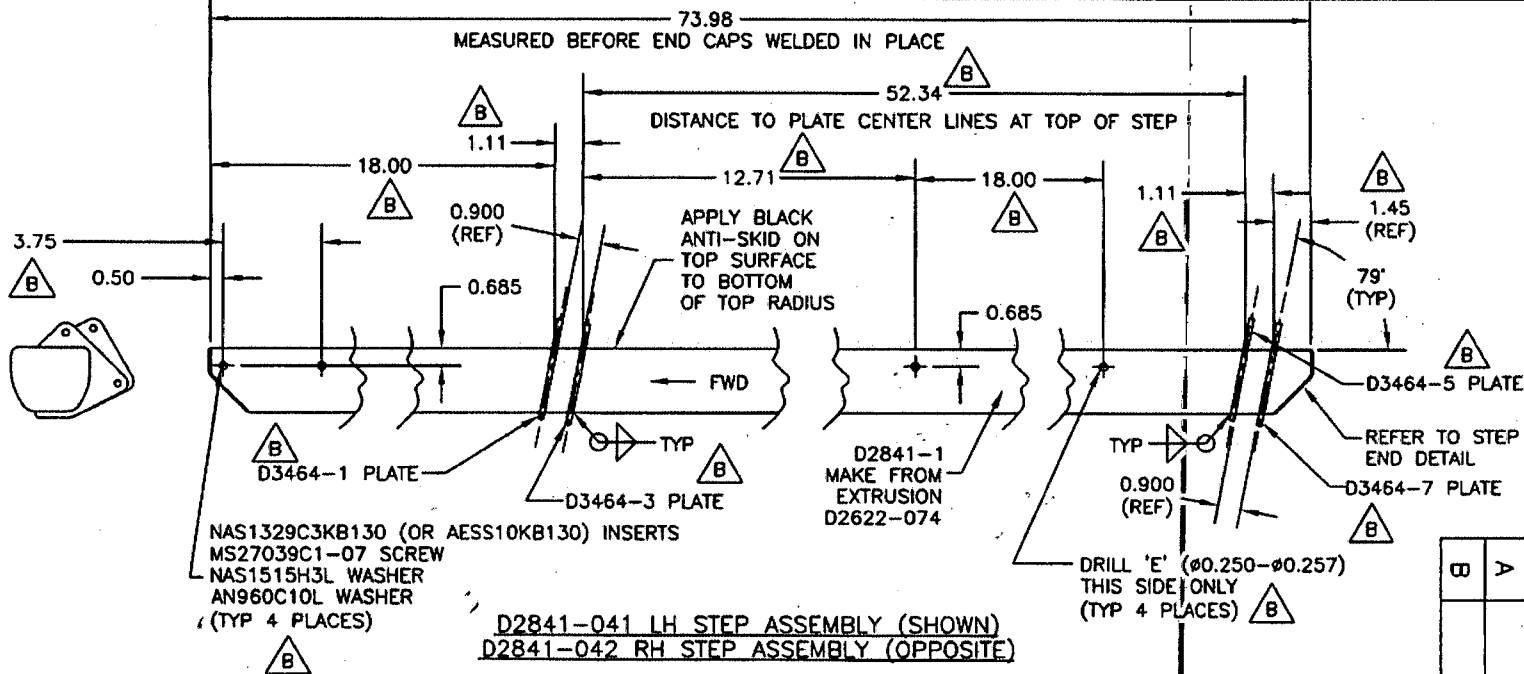
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# DART



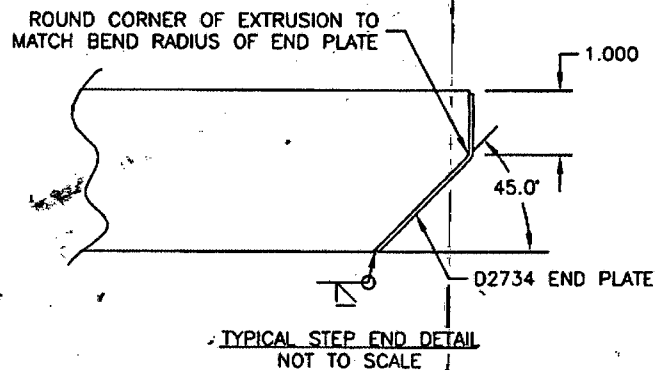
## D2841-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2841-041	LH STEP ASSEMBLY
	X	D2841-042	RH STEP ASSEMBLY
1	1	D2622-074	EXTRUSION
1	1	D3464-1	PLATE
1	1	D3464-3	PLATE
1	1	D3464-5	PLATE
1	1	D3464-7	PLATE
2	2	D2734	END PLATE
4	4	NAS1329C3KB130 (OR AESS10KB130)	INSERT
4	4	MS27039C1-07	SCREW
4	4	NAS1515H3L	WASHER
4	4	AN960C10L	WASHER

NOTE: ALL WELDS SHALL  
BE 100% VISUALLY  
INSPECTED BY A QUALIFIED  
INSPECTOR PER DART  
QSI 004

**D2841-041/-042 STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.2  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



RELEASED  
05-11-14

RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
WITHOUT NOTICE  
WORK ORDER  
NO. 33914  
P/O 06-11-83

DESIGN KE	DRAWN BY JH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED JH	APPROVED JH	DRAWING NO. D2841	REV. B SHEET 1 OF 1
DATE 05.09.21	TITLE 206B FLOAT STEP ASSEMBLY SCALE NTS		
A	98.10.14	NEW ISSUE	11
B	05.09.21	RE-DESIGN, ADD D2843-1/ $\frac{3}{16}$ 3/16 5/16 7/16	

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